

Date: Thursday, 17/04/2008 10:59:34 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE		
Job Number	: 38668		Part Number	: D2890		
Estimate Number	: 10377		Drawing Number	: D2890 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 17/04/2008		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 30/05/2008		
Previous Run	: 38667		Qty:	1 Um: Each		
Written By	:					
Checked & Approved By	: <u>JLJ 08.4.19</u>					
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty	Part #	Description
	1	D6008-180	Crosstube extrusion
2.0	BENDING	BENDING MACHINE - SKIDTUBES	
		Comment: BENDING MACHINE	
		1-Bend D2890 as per Dwg D2890 and Folio FT002	
3.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
4.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Deburr and Polish	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:34 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38668

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WYD 38314 (-107)

08-07-23 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

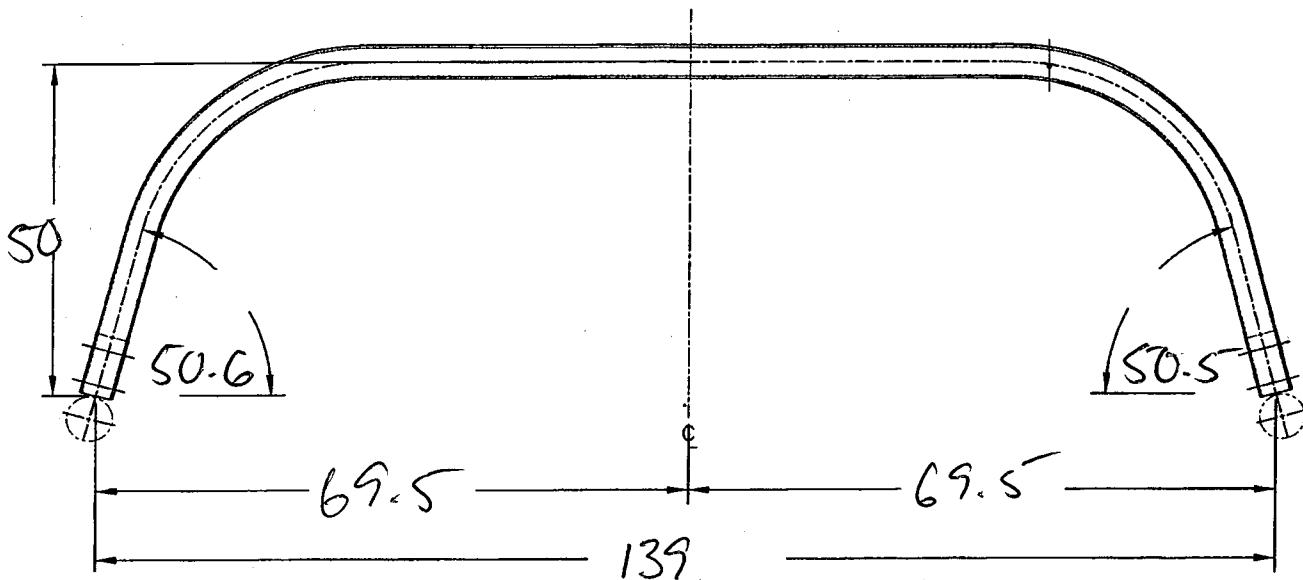
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38668
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



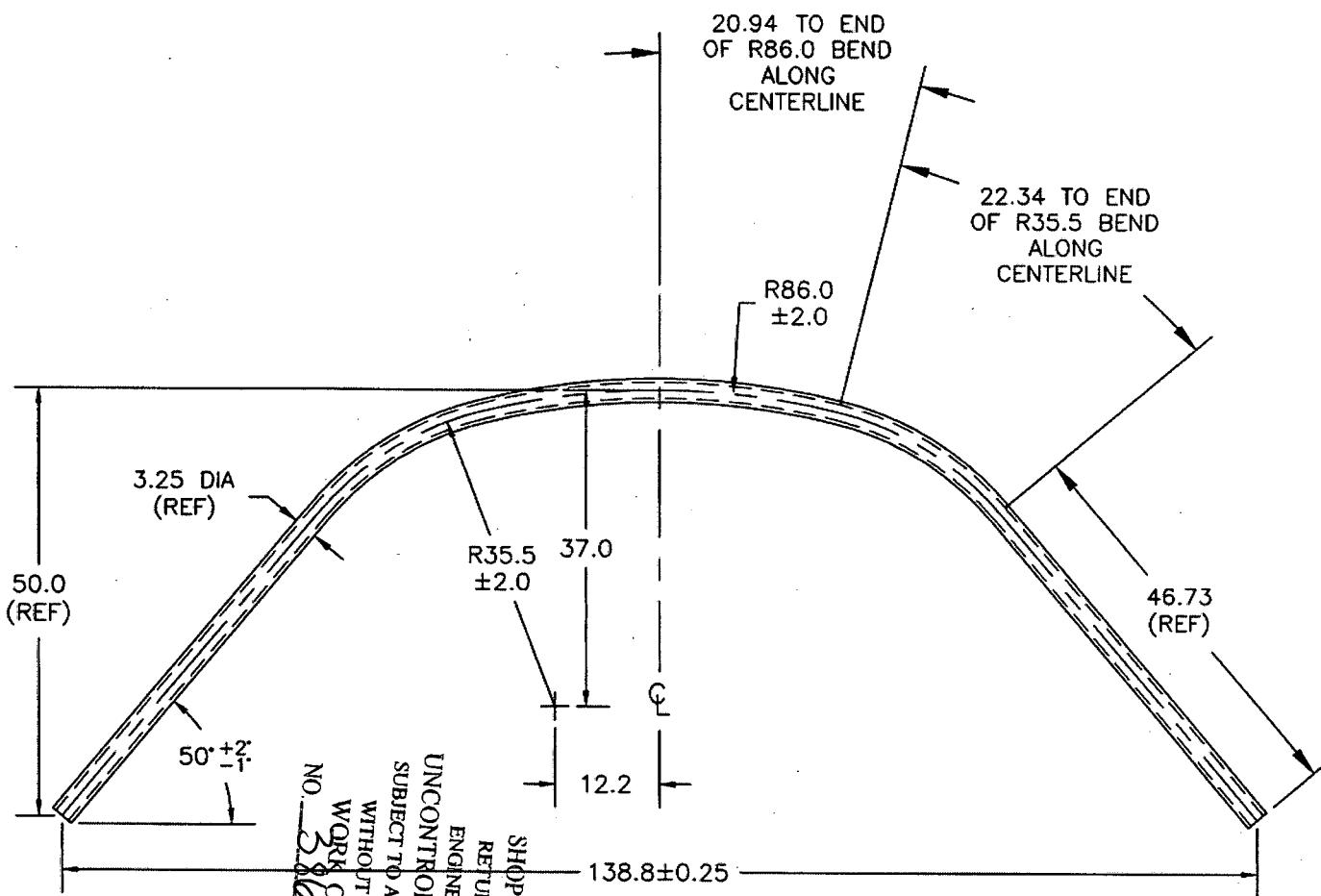
Comments

QC15 Inspection	
Date	28.07.23

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	JM

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GIVEN**RELEASED**
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. B
		D2890	SHEET 1 OF 1
DATE	TITLE	SCALE	
A 02.10.18	AFT CROSSTUBE	1:20	
B 02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

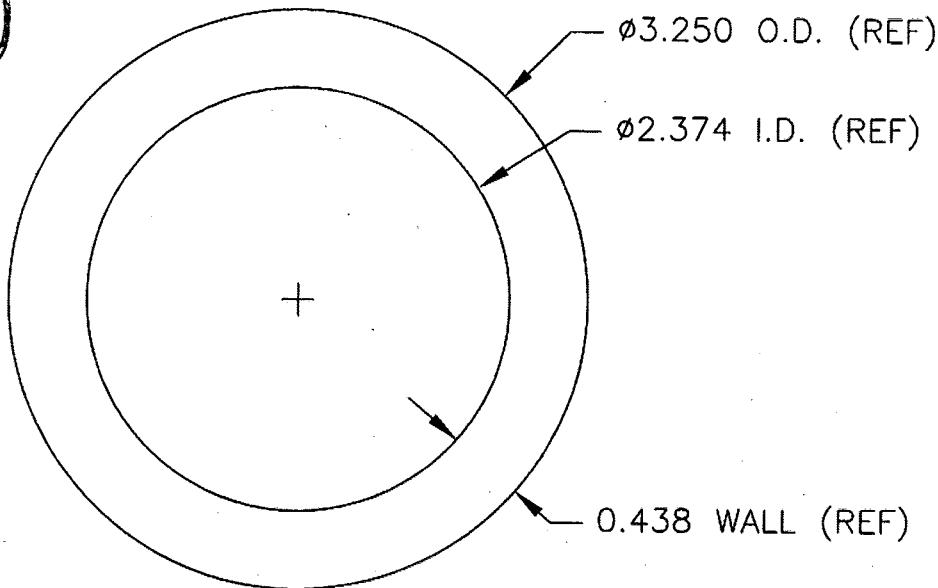




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1 SCALE 1:1
00.11.17		TITLE CROSSTUBE MATERIAL
A	00.11.17	NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

1) D6008-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES

EG. 180" LONG TUBE: D6008-180

2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38668